

5/29
DART AEROSPACE LTD

Work Order:

23614

Description: Blade

Part Number:

D2741

Drawing: D2741 Rev. B2

Qty:

20 19

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	JA	05.06.21	20
2	METAL	Cut blanks 13.850" long +0.063" -0.000" Material: 4130 steel bar 0.50" x 3.00" Batch: M17494	SD	05.06.24	20
3	CNC CELL	Machine per folio FA108	BC	05.06.26	20
4	QC	Inspect Level 2	BC	05.06.26	20
5	QC	Inspect Level 8	ML	05.06.26	20
6	METAL	Deburr	BC	05.06.26	20
7A	METAL	Bend per Dwg D2741	J	05.06.27	19 PTO
8	QC	Inspect Level 5	U	05.06.27	19
9	PURCHASING	Issue P/O: 2008304 Harden material as per Dwg D2741 Min. Ultimate Tensile Strength = 152 ksi (34-40 HRC) Min. Yield Tensile Strength = 141 ksi Test report or Certification required	U	05.07.0	
10	RECEIVING	Receive and Inspect for transit damage Ensure Test report or Certification attached	DL	05/07/22	19
11	QC	Inspect Level 5	U	05.08.04	19
12	FINISHING	Powder Coat White (Ref. 4.3.5.2) per QSI 005 4.3	ML	05.08.05	19
13	QC	Inspect Level 3	CL	05/08/05	19
14	STORES	Identify and stock	CL	05/08/05	19
15	EXPEDITING	Close W/O Cost / part 57.85 sub 05/08/05 (19) 57.74	CL	05/08/07	19

Rev	Date	Change	Revised By	Approved
A	98.09.10	New Issue	DS/CP	
B	99.03.22	Material hardened after counterbore	DM	
C	00.11.01	Removed P/O for Powder Coat - in house process	EC	
D	00.11.15	Removed P/O turning - in house process	EC	

7b	GA	Grind out machine marks	SD	05/06/28	19
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RELEASED

EC 00.11.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 23614		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-06-27	7	1 part scrap over bent due to program error.	V	Scrap is destroyed, use as a sample part for bench.	J 05-06-27	J 05-06-27	V	J 05-06-27

Part No: _____ PAR #: _____ Fault Category: Prod / Landing Gear NCR: Yes No DQA: [Signature] Date: 05/08/07

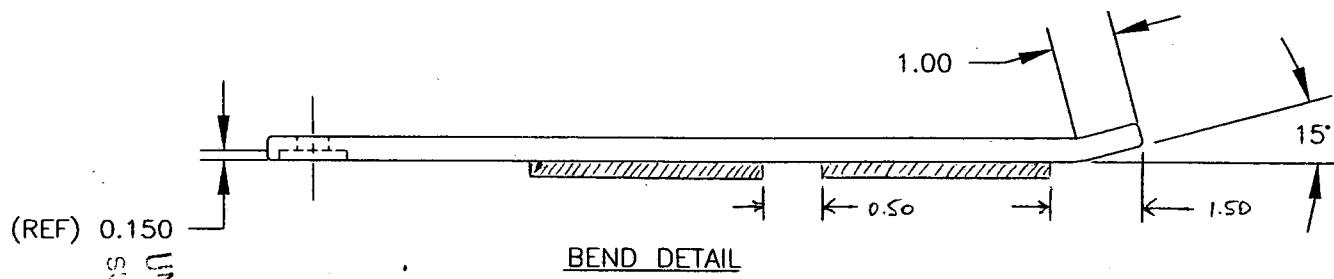
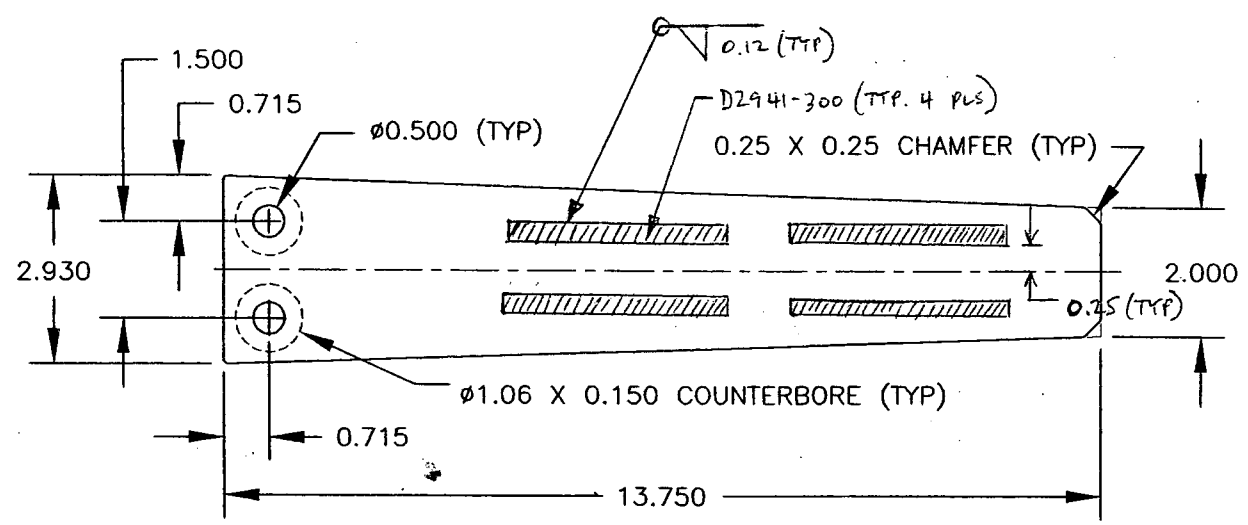
NOTE: Date & initial all entries

QA: N/C Closed: [Signature] Date: 05.08/08

DART

QA COPIES

RELEASED
98-11-03 DS



MATERIAL: AISI 4130 STEEL 0.375 THICK
MIN. ULTIMATE TENSILE STRENGTH = 152 ksi (34-40 HRC)
MIN. YIELD TENSILE STRENGTH = 141 ksi
FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL SHARP EDGES 0.030 TO 0.060

#01.01.31
#01.01.31
TO MAKE D2741-041, WELD 2941-300 (4) AS SHOWN ABOVE. REMOVE POWDER COAT FROM SURFACE OF D2941-300
TO MAKE D2741-043, WELD 7560 HARDCOAT ROD INSTEAD OF D2941-300

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
#1	JP	FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
#1	JE	D2741	
DATE	TITLE	SCALE	
98.09.01	BLADE	1:3	
A	98.04.16	NEW ISSUE	
B	98.09.01	CHANGE C'SINK TO C'BORE	
B1	01.01.31	ADD 2941-041/-043 OPTIONS	
B2	01.02.25	ADD ROCKWELL HARDNESS	

#01.02.25
#01.02.26
B2

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ENGINEERING
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WITHOUT NOTICE
ORDER
NO. 23614

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 20, 2005
03:23 pm

Work Order No : 0023614
Project Name : D2741
Project For : WK529
Work Order Type : Main
Main WO Number :
House Part Number : D2741
Description : Blade
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 06-20-05
Est Finish Date : 07-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00



VAC AERO

INTERNATIONAL INC.

RELEASE NO.

GST No. : R105468102

OAK 66350-1



HEAD OFFICE
1371 SPEERS ROAD, OAKVILLE, ONTARIO
CANADA L6L 2X5
TEL: (905) 827-4171 FAX: (905) 827-7489



2009 WYECROFT ROAD, UNIT B
OAKVILLE, ONTARIO
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QUEBEC DIVISION
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC
CANADA H4S 1C5
TEL: (514) 334-4240 FAX: (514) 334-6269

07/19/2005

MM/DD/YYYY

PAGE : 1

1DAR01

BILL TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
07/19/2005		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
2008304		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D2741	BLADE	EA	39	39	
<p>Process Specifications: HARDENED PER DWG. D2741 TO 152 KSI MINIMUM HRC 34-40 MATERIAL: 4130</p> <p>B22958, 19 PCS B23614, 20 PCS</p>					

100% HARDNESS TESTED
39/40 HRC

5F



I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Authorized Q.C. Inspector



VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT

